

is combined with a workpiece-machining device and a workpiece-storage device.

Figure 2 is a front view of the workpiece-machining facility.

Figure 3 is a side view of the workpiece-machining facility.

Figure 4 is a top view showing the general operation of the workpiece-transfer device in the workpiece-machining facility.

Figure 5 is a top view showing a suction-pad arrangement of the workpiece-transfer device.

Figures 6A and 6B are partial front and side views of the suction-pad arrangement, respectively.

Figure 7A is a top view of an advancing mechanism of the suction pad, Figure 7B is a sectional view of the advancing mechanism, and Figure 7C is an exploded view of Figure 7A as seen from direction C.

Figures 8A and 8^C_A are explanatory drawings each showing in top view a form of material-loading operation by the workpiece-transfer device.

Figures 9A and 9B are explanatory drawings showing in top view a form of material-unloading operation by the workpiece-transfer device.

Figures 10A to 10B and 10C are explanatory drawings showing in top view another form of material-unloading operation by the workpiece-transfer device.

Figures 11A and 11B are explanatory drawings showing in top view yet another form of material-unloading operation by the workpiece-transfer device.

Detailed Description of the Preferred Embodiments